

Date: Tuesday, 01/04/2008 3:11:16 PM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WHEEL ASSEMBLY
Job Number : 37614	
Estimate Number : 12102	
P.O. Number :	Part Number : D33975
This Issue : 01/04/2008 S.O. No. :	Drawing Number : D3397 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : 26/02/2008 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 36598	Material :
Written By : <u>02.04.01</u>	Due Date : 10/03/2008 Qty: 12 Um: Each
Checked & Approved By :	
Comment : est rev. A New issue EC	

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	M1020TR1375W125	COLD DRAWN ROUND TUBE
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Comment: Qty.: 0.1313 f(s)/Unit Total : 1.5750 f(s)

AISI 1020-1025 ROUND TUBE

Dia. 1.375" x 0.125" wall

batch: M102210

20 08/07/09

20 08/09/30

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: Doosan Lathe

1- Turn as per Folio FA734 Rev. A & Dwg D3397 Rev. A

2-Deburr per dwg D3397

20 08/04/30

20 08/07/09

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 08/04/30 20 08/07/09

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 08/07/09

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

20 07/14

(12)

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Drawing Name: WHEEL ASSEMBLY

Job Number: 37614

Part Number: D33975

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/14 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

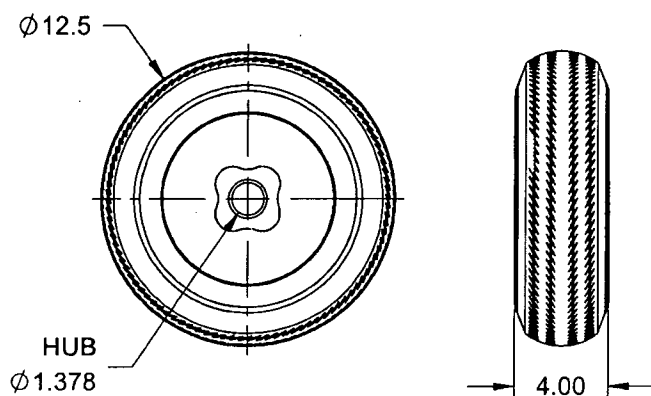
Job Completion



mf 08-07-14



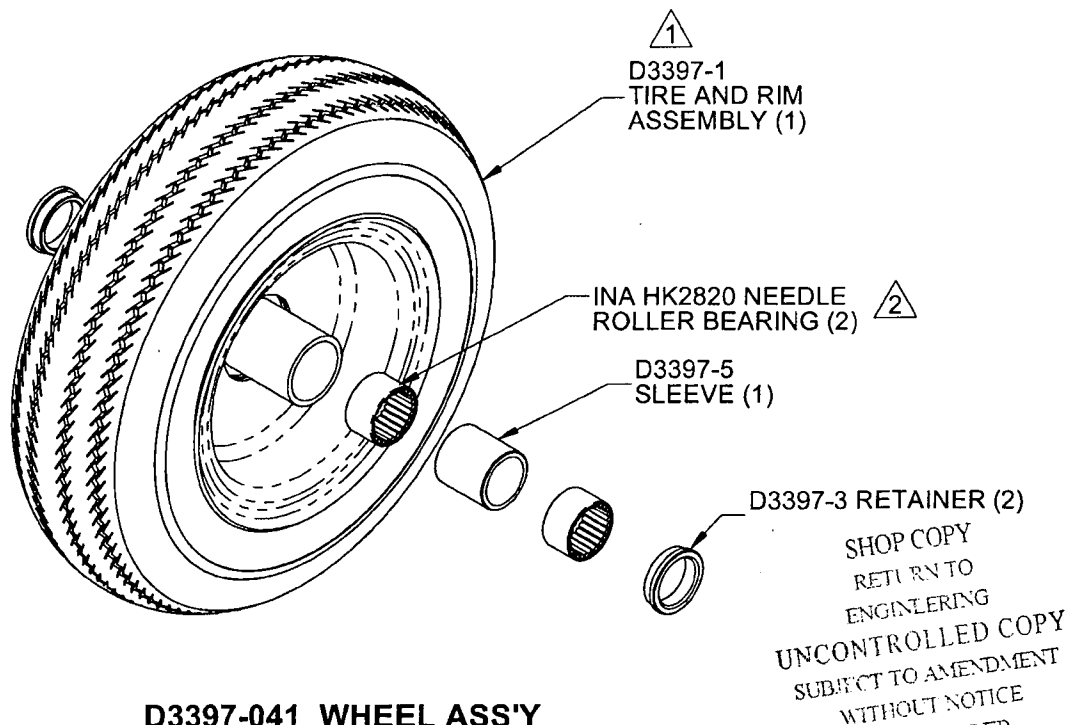
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3397	REV. A SHEET 1 OF 3
DATE 05.02.10		TITLE WHEEL ASSEMBLY	SCALE 1:8
A	05.02.10	NEW ISSUE	



WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATATION LOAD
TIRE: Ø12.4 X 4.1 RIM: Ø6.0 X 4.0	445 LBS	50 PSI*

1 D3397-1 TIRE AND RIM ASS'Y

RELEASED
06/03/07



D3397-041 WHEEL ASS'Y

NOTES:

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 4997T28. SCRAP ORIGINAL BEARING
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) INFLATE TIRE TO MAX. 50 psi
- 7) APPLY RUST INHIBITOR NOT PROTECTED BY PAINT. RUST INHIBITOR P/N: LPSC30316

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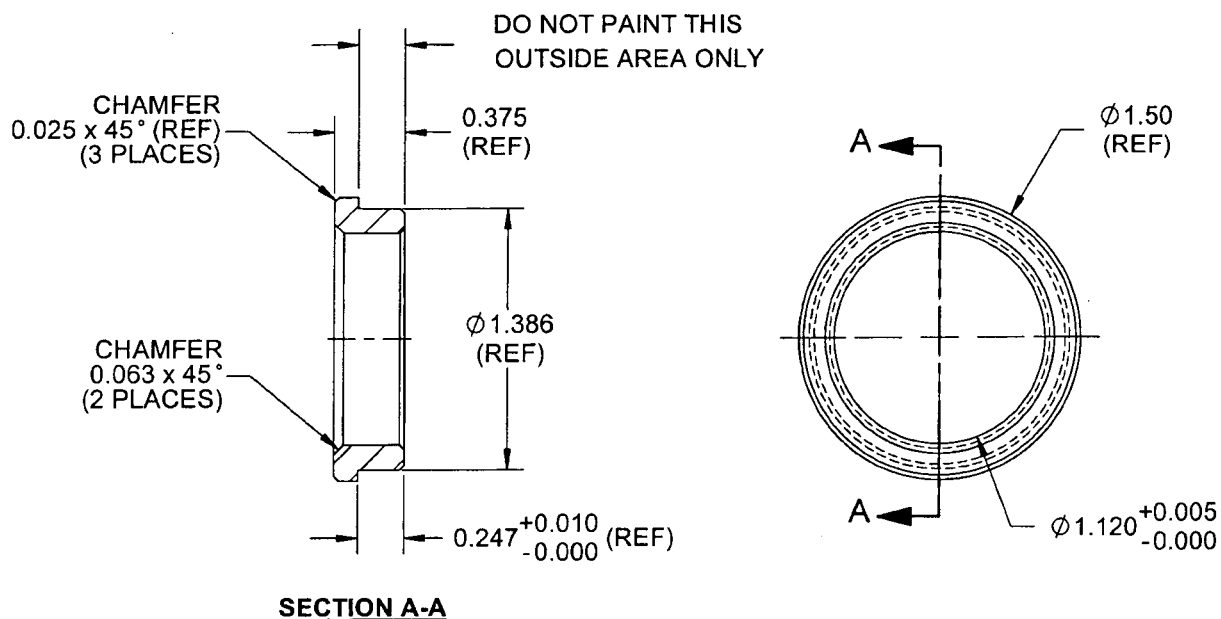
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DATE 05.02.10		TITLE WHEEL ASSEMBLY	SCALE 1:1

RELEASED
[Signature] 06/03/09

SPECIFICATION CONTROL DRAWING



D3397-3 RETAINER

NOTES:

- 1) MATERIAL: REMOVE FROM McMASTER-CARR P/N 4997T28 AND MODIFY AS SHOWN
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.025

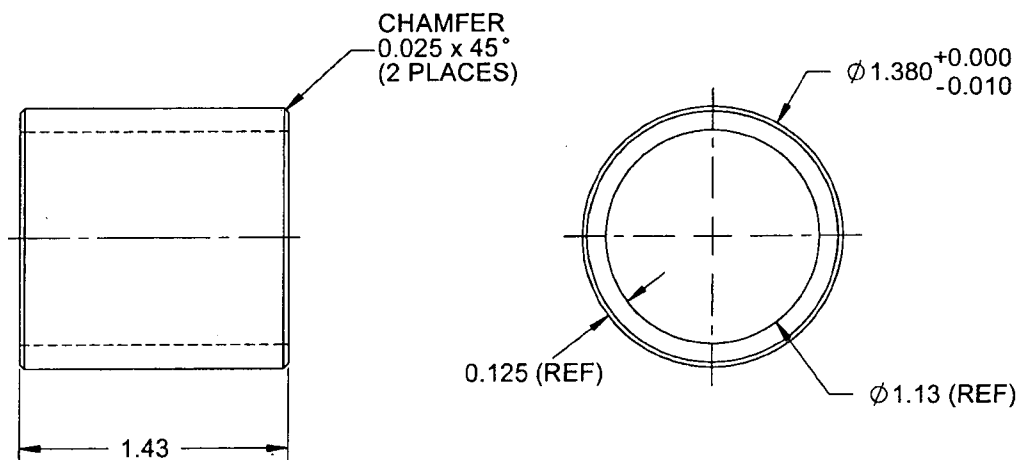
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3397	REV. A SHEET 3 OF 3
DATE 05.02.10		TITLE WHEEL ASSEMBLY	SCALE 1:1

RELEASED
06/03/09**D3397-5 SLEEVE****NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00.
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR1.375W.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.025

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DART AEROSPACE LTD		Work Order:	
Description: Cross Tube Assembly <i>Sleeve</i>		Part Number:	<i>D3397-5</i>
Inspection Dwg: <i>D3397</i> Rev: <i>A</i>		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	<i>.025 x .95</i>	<i>+/- .010 to</i>	<i>.025 x .45</i>				
	<i>1.43</i>	<i>+/ +/- .03</i>	<i>1.433</i>				
	<i>1.380</i>	<i>+/- .010</i>	<i>1.378</i>				
	<i>.125</i>	<i>+/- .010</i>	<i>.124</i>				
	<i>1.13</i>	<i>+/- .030</i>	<i>1.133</i>				
SIDE B							

Measured by: <i>RO</i>	Audited by: <i>J.F.</i>	Prototype Approval:	N/A
Date: <i>08/07/09</i>	Date: <i>08/07/09</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	<i>[Signature]</i>